

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022038**Date Inspected:** 16-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. An Qing xiang / Mr. Sha zhi			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Assembly bay- 14.

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3014J-012. Welder is identified as 066443. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint identified as OBW13A-018. Welder is identified as 067764. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint identified as SEG3020AW-092. Welder is identified as 037779. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

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SMAW repair welding of weld joint identified as SEG3020U-588. Welders are identified as 067588,045246 and 051348. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-2G (2F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20419. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-19837.

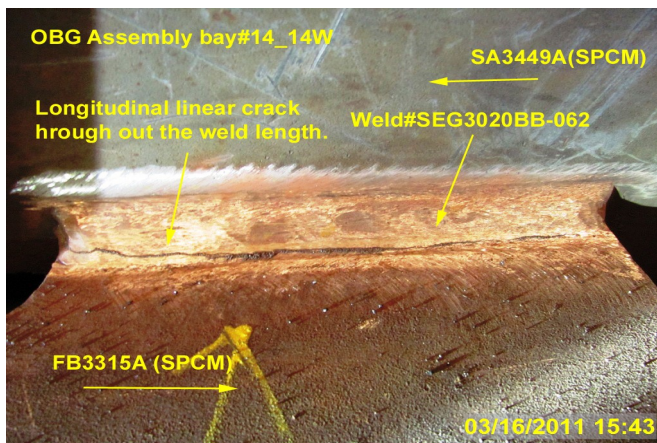
SMAW welding of weld joint identified as SEG3020AL-106. Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Sun tian liang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020V-055. Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as SEG3020P-239. Welder is identified as 0684455. ZPMC Quality Control (QC) is identified as Mr. Sun tian liang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

During random in process visual inspection of OBG member identified as SA3449A and FB3315A, this QA observed a longitudinal linear crack through out the weld length on weld joint identified as SEG3020BB-062. The weld is a fillet weld joining to shear plate (SA3449A) to floor beam (FB3315A). The weld is designated as SPCM. This QA marked the crack and informed ZPMC Quality Control (QC) identified as Mr. Zhulin of this issue. Mr. Zhulin informed this QA that the crack would be corrected in a manner compliant with the contract documents. See attached photos for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
